

5138

DART AEROSPACE LTD	Work Order :	24092
Description: Step Extrusion 04.04.2717 05.02.10 CP	Part Number:	D2622-120C
Drawing: D2622 Rev. C1	Qty:	136

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	JH	05.08.23	126
2	PG	Issue P/O: <u>2008532</u> a) Extrude as per Dwg D2622 Rev. C 05.02.10 CP b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 120" long g) Bon L Canada Inc. tool # 897123 Rev. A h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required	JH	05/08/24	126
3	RG	Inspect for transit damage Ensure Certification are attached	CJ	05/09/13	136
4	QC6	Inspect dimensions per Dwg D2622 Check Pull test per Dwg D2622 for compliance page attached. Check hardness with Webster tester	JH	05/11/02	136
5	ST	Identify and Stock as D2622-120C	JH	05/11/02	136
6	AC	Cost / part <u>24.17</u>	JH	05/11/03	136
7	DC	Close W/O <u>ZY.13</u> Inspect Level 21	JH	05/11/03	136

Rev	Date	Change	Revised By	Approved
A	02.11.12	New Issue	KJ RF	

RELEASED
02.11.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-11-02	4	Damage on ends of extrusion up to 4" long on a qty of 4, and dents in center of 2 extrusions.	RD 05-11-02	use damaged mat'l for start steps, and notify Bon L (supplier) of transport damage	u 05-11-02	2 05-11-02	VB 05-11-02	2 05-11-02

Part No: D2622-120C PAR #: 411

Fault Category: Bulk

NCR: Yes No DQA:

Date: 05/11/02

NOTE: Date & initial all entries

QA: N/C Closed:

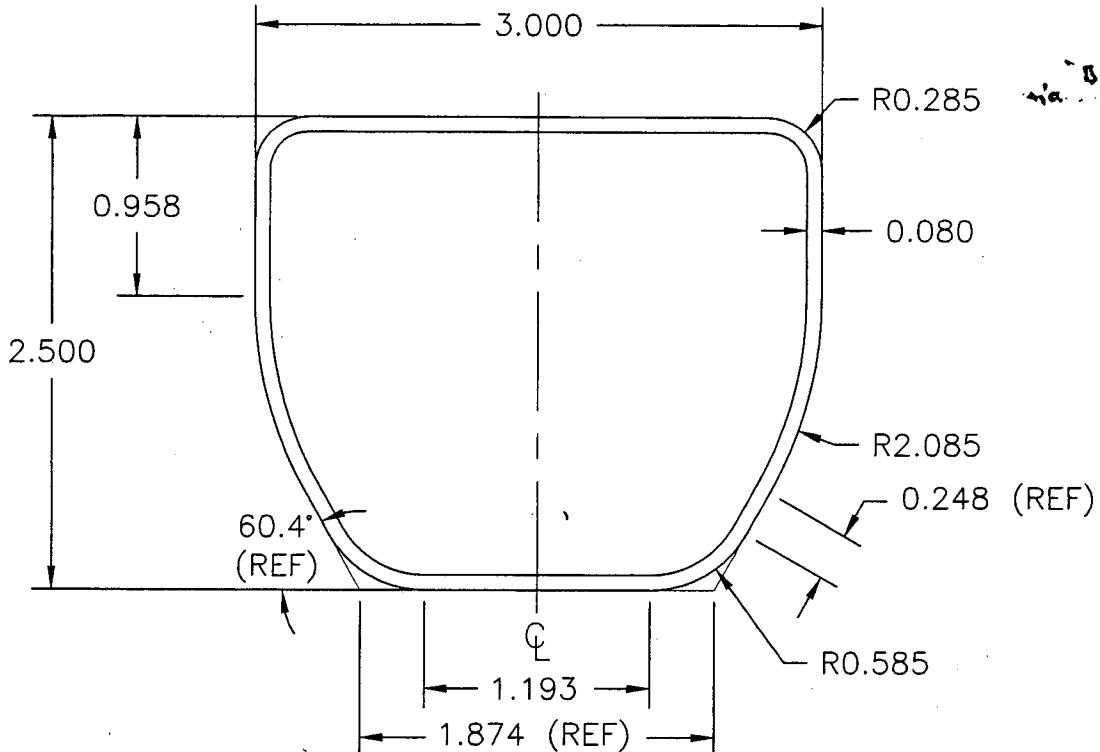
Date: 05/11/02



COPY ISSUED

RELEASED
02.09.11 CP

DESIGN KE	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED CP	APPROVED CP	DRAWING NO. D2622
DATE 02.09.11		REV. C SHEET 1 OF 1
		SCALE 1:1
A	96.11.29	NEW ISSUE
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.
CP CP	02.10.04	ADD 'REV. A' TO DIE NUMBER.



D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
 MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

WORK ORDER
NO. 24092

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 18, 2005
10:59 am

Work Order No	:	0024092	Department Code:
Project Name	:	D2622-120C	Burden Flags : NNNNNNN
Project For	:	WK538	WO Status : Open
Work Order Type	:	Main	Invoice State : Not Invoiced
Main WO Number	:		Invoice Date :
House Part Number	:	D2622-120C	Invoice Number :
Description	:	Extrusion	Invoice Amount : 0.00
Manufactured	:	Yes	
Amount Req'd	:	10121	
Amount Done	:	0	Order Entry No :
Start Date	:	08-17-05	OE Value : 0.00
Est Finish Date	:		Est Mark Up : 0.000%
Act Finish Date	:		Actual Mark Up : 0.000%
Drawings Reqd	:	No	
Ok for Approval	:		
Approval Rec'd	:		\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
<hr/>					
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00



CERTIFICATE OF COMPLIANCE

BON L CANADA INC

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Check Date	Car. No.	Sales Order	Page
09/07/05	127011	66812	1
Printed On	By:	Lot	Date
2008532	00276719	66812010	9/07/05

Sold To:	Ship To:
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No.	Part No.	Item Description	Cust Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622
Gross Weight	581 KGS		
Net Wt.	559 KG	136 PC	415 M
Specification:	Part Desc:		
AMS-QQ-A-200/8 & ASTM B221-00			

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend Drift	HR-E
1	303.5 / 44.0	275.9 / 40.0	10.8	.0	.0	90
2	307.6 / 44.6	278.0 / 40.3	10.3	.0	.0	91

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.666	.277	.283	.059	.885	.058	.005	.074	.000	.010	.017	.000	.000
.668	.242	.267	.052	.887	.055	.005	.062	.000	.009	.015	.000	.000
.634	.257	.256	.048	.873	.068	.005	.075	.000	.009	.016	.000	.000

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein.

Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Paul Dailleboust, QA Manager Signed for Bon L Canada